

**Work Order ID 110510**

Monday, December 23, 2013 9:59:16 AM

**\*110510\***

Page 1

Item ID: D3996-FE-832-EF

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Self-Clinching Fastener

Start Date: 12/23/2013 Start Qty: 500.00

**\*500\***

Cust Item ID:

Required Date: 12/30/2013 Req'd Qty: 500.00

**\*500\***

Customer:

Reference:

Approvals:

Process Plan: CLDate: 13/12/23

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3996

A

100

0.00

**\*100\***

Purchasing

Purchasing

Memo

Issue P/O: 22492

Purchase Part Number: FE-832-EF

Supplier: Interfast Inc.

Certificate of conformity is required

0.00

CL 13/12/23 (500)

110

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*110\***

Packaging

Packaging

Memo

0.00

B/4/01/8 (500)

**Work Order ID 110510**

Monday, December 23, 2013 9:59:16 AM

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Page 2

Item ID: D3996-FE-832-EF

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Self-Clinching Fastener

Start Date: 12/23/2013 Start Qty: 500.00

**\*500\***

Cust Item ID:

Required Date: 12/30/2013 Req'd Qty: 500.00

**\*500\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC6- Inspect dimensions to drawing

0.00

DAS

27

9-89

0.00

14/1/8

**\*120\***

QC

Memo

Quality Control

500

130

Identify as per dwg &amp; Stock Location

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

500x

DAS  
36  
9-89  
14/01/08

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

14-01-8

D3/01/2014  
14-01-8

# Picklist Print

Monday, December 23, 2013 9:59:14 AM

Page 1

Work Order ID: 110510

Parent Item: D3996-FE-832-EF

Start Date: 12/23/2013

Required Date: 12/30/2013

Parent Item Name: Self-Clinching Fastener

Start Qty: 500.00

Required Qty: 500.00

Comments: IPP RevA: new issue 09.11.11 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-832-EF PEM Insert		Purchased	No			110	Each	0.0000	1	500		12/24/01/9	(500)

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

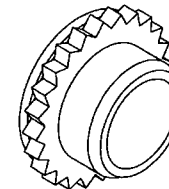
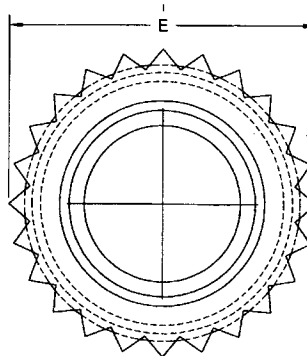
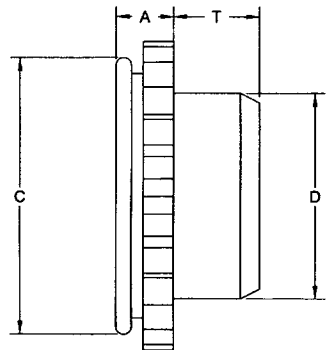
Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# SPECIFICATION CONTROL DRAWING



C/L 13/12/23  
W/O: 110510

## D3996-XXX-YYY-ZZZ SELF-CLINCHING FASTENER

THREAD SIZE	THREAD CODE ("YYY")	TYPE ("XXX")	A MAX (SHANK)	SHEET THICKNESS	C +0.000 -0.005	D MAX	E +0.005	T +0.015 -0.000	HOLE SIZE IN SHEET +0.003/-0.000	MIN DIST: HOLE CL TO EDGE	WEIGHT lb
#4-40 (0.112)	440	FEO	0.040	0.039-0.045	0.171	0.145	0.192	0.065	0.172	0.14	0.00031
		FE	0.060	0.059-0.070							0.00037
#6-32 (0.138)	632	FEO	0.040	0.039-0.045	0.212	0.180	0.244	0.075	0.213	0.17	0.00047
		FE	0.060	0.059-0.070							0.00068
#8-32 (0.164)	832	FEO	0.040	0.039-0.045	0.289	0.215	0.322	0.090	0.290	0.20	0.00098
		FE	0.060	0.059-0.070							0.00124
#10-32 (0.190)	032	FEO	0.040	0.039-0.045	0.289	0.245	0.322	0.110	0.290	0.20	0.00104
		FE	0.060	0.059-0.070							0.00120
1/4-28	0428	FE	0.060	0.059-0.070	0.343	0.318	0.384	0.120	0.344	0.28	0.00158

### NOTES

1) SPECIFICATION: PENNENGINEERING (PEM) MINIATURE SELF-CLINCHING FASTENER, SELF-LOCKING  
PEM P/N XXX-YYY-ZZZ

WHERE "XXX" = TYPE "FEO" (SHORT SHANK) OR "FE" (LONG SHANK) PER TABLE  
"YYY" = THREAD CODE PER TABLE  
"ZZZ" = FINISH CODE PER NOTE 2 BELOW

FOR EXAMPLE, #8-32 THREAD, LONG SHANK, ELECTRO-FILM FINISH:  
DART P/N = D3996-FE-832-EF  
PEM P/N = FE-832-EF

2) FINISH: FINISH CODE ("ZZZ") PER THE FOLLOWING:

"C" = CADMIUM YELLOW CHROMATE PER ASTM B766 CLASS 5 TYPE II  
"CI" = CADMIUM CLEAR CHROMATE PER ASTM B766 CLASS 5, TYPE III  
"EF" = ELECTRO-FILM PER MIL-PRF-46010  
"MD" = MOLYBDENUM DISULFIDE DRY FILM (STD PEM FINISH)

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

RELEASED  
2009-11-08

A	NEW ISSUE	CP	09.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN	 <b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. A	
DRAWN		SHEET 1 OF 1	
CHECKED		DRAWING NO. D3996	
MFG. APPR.		TITLE	
APPROVED		SELF-CLINCHING FASTENER	
DE APPR.	SCALE NTS		
DATE	09.10.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

# PURCHASE ORDER

Purchase Order ID **PO22492**

Purchase Order Date 12/23/2013

PO Print Date 12/23/2013

Page Number 1 of 1

Order From : VU-WES002

WESCO AIRCRAFT HARDWARE CORP  
PO BOX 802020  
SANTA CLARITA, CA 91380-2020  
USA

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FC 13/12/23

Contact Name  
Vendor Phone 661-775-7200  
  
Ship To Contact  
Ship To Phone  
Ship Via: FedEx PI collect  
Ship Acct:

Buyer  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 30  
Currency USD  
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	FE-832-EF  AS PER DWG D3996 REV. A B110510 ORDER P/N: FE-832-MD ACCEPTABLE AS PER DWG	PEM Insert	12/30/2013 Yes 12/30/2013		500.00 Each	\$0.28	\$138.50

Line Total: \$138.50

PO Total: \$138.50

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.  
No substitution or deviation without consent.  
Certificate of Conformity or Material Certification required - YES NO  
PST# 6122-5207

Change Nbr: 1



Change Date: 12/23/2013



**Wesco Aircraft Europe, Ltd.**

2000 32nd Ave; Lachine, QC H8T 3H7  
PH: / FAX: /

# Pack Slip

Pack Slip #   
Customer PO # 

Sales Order # 

Pack Slip #	Date	Page #
7154410	1/6/2014 5:55:43	1 of 1
Bill To #	Ship To #	
2440829 (IF110900_	2440829 (IF110900)	
Sales Order #	Ordered By	
7904828 SO	CHANTAL	
Payment Terms		
030 Net 30		
Customer PO #		
PO22492		
Salesperson	Related Order #	
Juillet, Carole		

**Bill To:**  
DART AEROSPACE LIMITED  
1270 ABERDEEN ST.  
HAWKESBURY ON K6A 1K7  
Canada

**Ship To:**  
DART AEROSPACE LIMITED  
1270 ABERDEEN ST.  
HAWKESBURY ON K6A 1K7  
Canada

Ship Inst: COL IF110900\_BILLA00

Carrier: Fed Ex Priority Overnight

Item #	Quantities			Part Number / Description	Certifications	Promise Date
	Shipped	Backorder	U/M			

**Rush HOT! PRI 4\*\*\*2 DAY RUSH!!\*\*\*\* S30**

1.000 500 0 EA FE-832-MD Cert-No certification level 12/23/2013

NUT

Customer P/N: FE-832-EF



S/C # Manufacturer's Lot #:  
01329533 D219086

Manufacturer Name  
Penn Engineering & MFG Corp

Lot Qty TSO/PMA  
500



Comments: Export Classification. EAR 99  
FREIGHT ACCOUNT NUMBER: 15179324-0

## Export Statement

**Certificate of Conformance** GST/TPS # R817791106 QPST/TVQ #1219005381TQ0001 **Total Weight** **Total # Boxes**

Wesco Aircraft certifies that all products are of new manufacture. Documentation from the manufacturer certifies that the product meets all applicable Government, Customer and/or Manufacturer's specifications and requirements. Wesco certifies that the whole of the supplies detailed hereon have been received under cover of the Release Certificate quoted above and are in the same condition as when received. This documentation is maintained on file permanently and available upon request.

I hereby certify that the Aircraft Parts, Appliances and or materials described hereon were acquired from a source of supply that is consistent with the conditions under which the department of Transport Distributor approval No. 178-94 has been granted certified by:

Signed:    
Quality Assurance Manager

We hereby certify that no returns will be accepted without WESCO Returned Material Authorization number. Only lot traceable material will be accepted for return.